



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A94-1130-01-01

Job Sheet 189270



Part No: RBE703A94-1130-01-01

Job Qty: 10 pcs *34 m.L.*

Part Name: Immobilizing Clip Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/6/19 *2/6/19*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev.A 17.08.08 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	10 pcs	2/8/19		0.00	10.00	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
130	QC 5	10 pcs	2/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
140	Packaging 3-1 - Stock - B4B	10 pcs	2/8/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S162244



Part: RBE703A94-1130-01-01

Job No: 189270

Serial No/Batch: S162244

Revision: K

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19

MAR 14 2019
DAS 40
9-89

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					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	10 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
						9-89
						MAR 15 2019

Part Op 120 - (Small Fab) Assemble as per DWG. Sheet 2
 Descriptions: 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

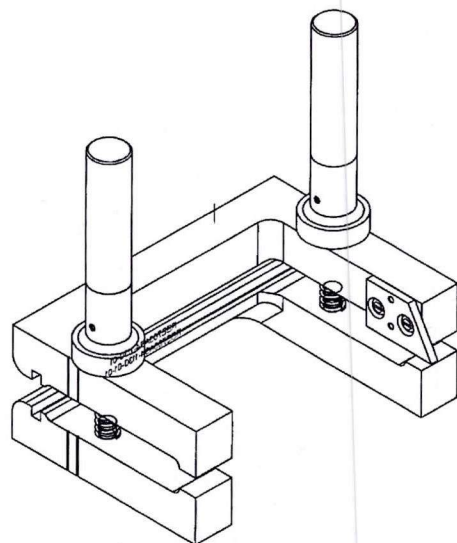
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90353A217	Pan Head Machine Screw M4 x 0.7mm x 20mm	6 20 Ea (2 ea)	120-Small Fab - 1	FM138414-5
91166A270	Washer, M8	12 40 Ea (4 ea)	120-Small Fab - 1	11X 5091267 AX
91595A112	Dowel Pin ØM3 x 12mm	6 20 Ea (2 ea)	120-Small Fab - 1	5122134
98296A881	Roll Pin Ø1/8 X 3/4	6 20 Ea (2 ea)	120-Small Fab - 1	FM138414-33
RBE703A94-1130-01-03	Bottom Fixture 1	3 10 pcs (1 ea)	120-Small Fab - 1	5126190
RBE703A94-1130-01-05	Fixture Handle	6 20 pcs (2 ea)	120-Small Fab - 1	5126642
RBE703A94-1130-01-07	Handle Stud	6 20 pcs (2 ea)	120-Small Fab - 1	1X5059557 AX
RBE703A94-1130-01-09	Bottom Fixture 2	3 10 pcs (1 ea)	120-Small Fab - 1	5126668
RBE703A94-1130-01-11	Angle Indicator	3 10 pcs (1 ea)	120-Small Fab - 1	5120250
RBE703A94-1130-01-13	Compression Spring Ø1.25mm x 11.25mm OD x 44.5mm	6 20 pcs (2 ea)	120-Small Fab - 1	5156510

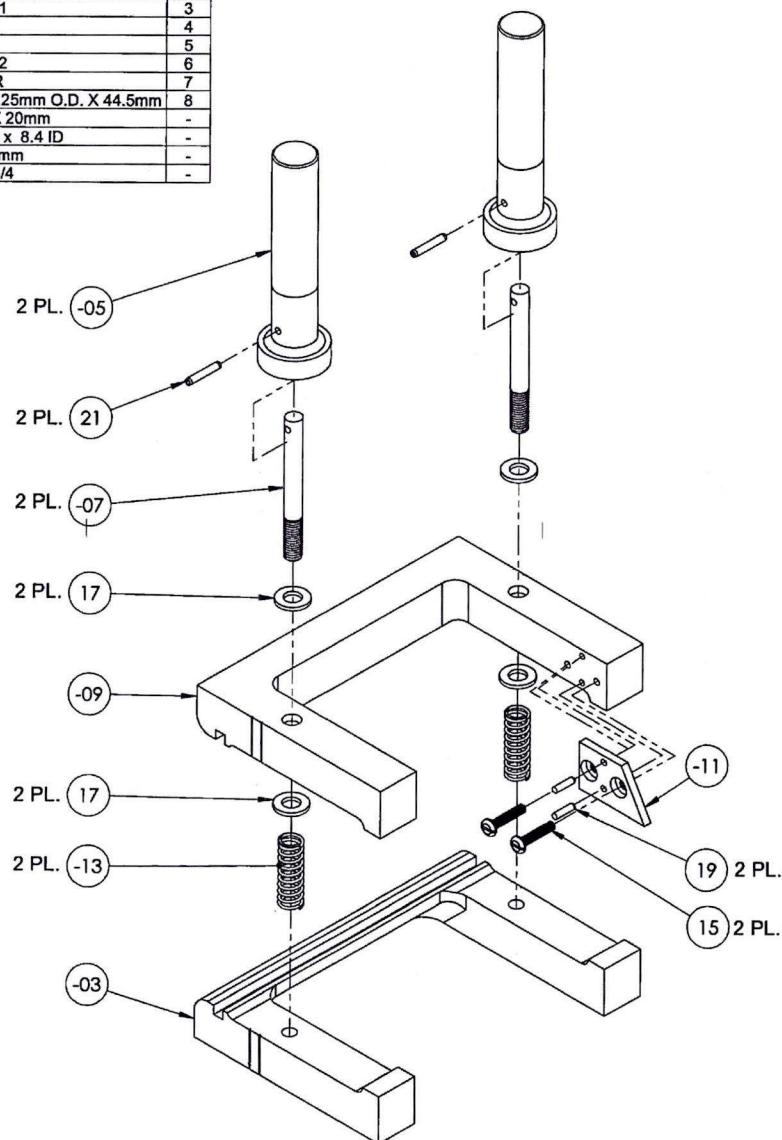
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	90353A217	20	31	0
	91166A270	40	165	0
	91595A112	20	129	0
	98296A881	20	181	0
	RBE703A94-1130-01-03	10	5	0
	RBE703A94-1130-01-05	20	11	0
	RBE703A94-1130-01-07	20	10	0
	RBE703A94-1130-01-09	10	3	0
	RBE703A94-1130-01-11	10	11	0
	RBE703A94-1130-01-13	20	0	0
Part Specifications				
Specifications could not be found.				

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ITEM #	QTY	PART #	TITLE	PG
-03	1	RBE703A94-1130-01-03	BOTTOM FIXTURE 1	3
-05	2	RBE703A94-1130-01-05	FIXTURE HANDLE	4
-07	2	RBE703A94-1130-01-07	HANDLE STUD	5
-09	1	RBE703A94-1130-01-09	BOTTOM FIXTURE 2	6
-11	1	RBE703A94-1130-01-11	ANGLE INDICATOR	7
-13	2	RBE703A94-1130-01-13	COMPRESSION SPRING Ø1.25mm X 11.25mm O.D. X 44.5mm	8
15	2	McMaster#90353A217	PAN HEAD M4 X 0.7mm X 20mm	-
17	4	McMaster#91166A270	FLAT WASHER M8 x 16 OD x 8.4 ID	-
19	2	McMaster#91595A112	DOWEL PIN ØM3 X 12mm	-
21	2	McMaster#98296A881	SPRING PIN Ø1/8 X 3/4	-



RBE703A94-1130-01-01 IMMOBILIZING CLIP ASSY



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189270 MJS

19-01-22

		Hawkesbury, Ontario, Canada	
		TITLE	
IMMOBILIZING CLIP ASSY		REV K	
DWG NO. RBE703A94-1130-01-01		REV K	
DESIGN BY: VM 9/8/2017	XXX ± .005 FRACTIONS 2/16	ANGLES ± 5°	
DRAWN BY: VM 11/24/2017	XX ± .01	SURFACES ± 125	
CHECKED: WM 11/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		
MFG. APPR: DP 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
APPROVED: WM 11/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING		
DATE: 11/24/2017	SCALE: NTS	WEIGHT: N/A	SHEET 2 OF 17
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			